

Work Order ID 55848

February 3, 2010 12:27:55 PM

Page 1

Item ID: D4005-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 2/03/10

Start Qty: 2.00

Cust Item ID:

Required Date: 2/10/10

Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10-2-03*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4005

A-PRELIM

now Rev A

0.00

100



Waterjet

0.00

FLOW CNC Waterjet

2024 .040

Memo

1-Cut as per Dwg

Dwg Rev: *PRF*Prog Rev: *Lim*

2-Deburr if necessary

0.00

SAO 10-02-05

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*MAT NOT PULLED**IB 10-2-4**(4)**IB 10-2-4***PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55848

February 3, 2010 12:27:55 PM



Page 2

Item ID: D4005-9

Accept



Setup

Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/03/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

27 S 10/02/09



QC

Memo

0.00

Quality Control

(x4)

130

Bend as per dwg

0.00

SB 10/02/09



Brake NC

Memo

0.00

Brake NC

(3)

(1)

PTO

E 140 => QCS inspect work to current step -> S 10/02/09

(+3)

150

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10.02.10



HandFinish

Memo

0.00

Hand Finishing

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4005-9 PAR #: _____ Fault Category: _____ NCR: Yes No ^{Prelim Stage} DQA: [Signature] Date: 10/2/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>55848</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/02/09</u>	<u>130</u>	<u>Use 1 piece for clamping set up PC process</u>	<u>[Signature]</u>	<u>Scrap & destroy no replace</u>	<u>Sh</u> <u>10/02/09</u>	<u>S</u> <u>10/02/09</u>	<u>[Signature]</u> <u>05/04/2</u>	<u>S</u> <u>10/02/09</u>

NOTE: Date & initial all entries

Work Order ID 55848

February 3, 2010 12:27:55 PM

Page 3

Item ID: D4005-9

Accept

Revision ID:

Item Name: Angle

Start Date: 2/03/10

Start Qty: 2.00

Required Date: 2/10/10

Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

~~QC~~ - Inspect part completeness to step on W/O

0.00

QC

Quality Control

5 QC3

Memo

0.00

170

Identify as per dwg & Stock Location: 5+117

0.00

Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

POSITIVE RECALL

RECEIVED 10-02-03 AUTH

RELEASED 10-06-28 DATE

10/06/28

MF 10-2-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 12:28:00 PM

Page 1

Work Order ID: 55848



Parent Item: D4005-9



Parent Item Name: Angle


Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Start Date: 2/03/10

Required Date: 2/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name											Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Required Qty: 2.00			
																						Date Issued	Status	
M2024T3S.040												Purchased	No					sf	509.7133	0.0260				
																								
2024-T3 .040 sheet																								10-2-24

18 10-2-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

509.7132789

110305

184

110337

6.4

111786

32.0665789

112291

49.4264

112331

82.8641

113162

154.9562

113005

113008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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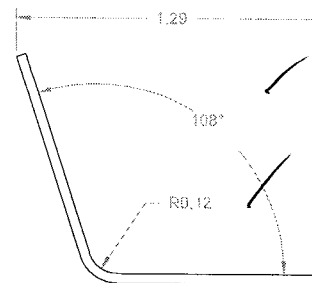
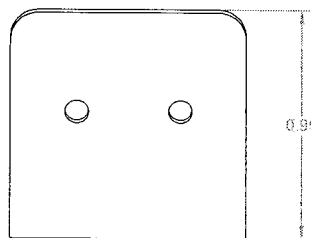
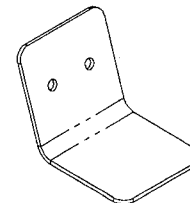
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-9	JCA-M47-2-08

x 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55841

B/KO-2-03



D4005-9 ANGLE

See Rev. A

PRELIMINARY ISSUE

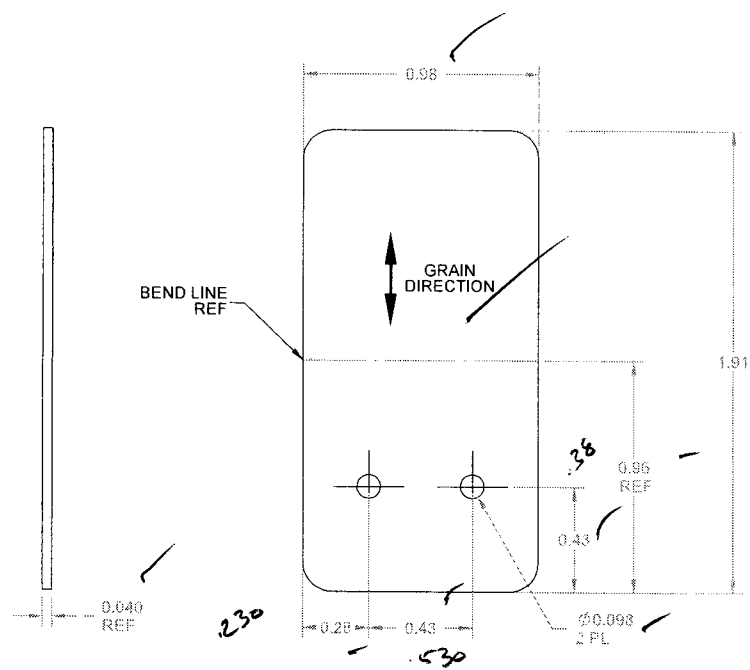
09.10.19

NOTES:

- 1) MATERIAL: MADE FROM D4005-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-9" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4005 REV. PA1
MFG. APPR.		SHEET 10 OF 15
APPROVED		TITLE FORWARD RESTRAINT SCALE NTS
DE APPR.		
DATE	09.10.19	

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D4005-9F FLAT PATTERN

See Rev. A

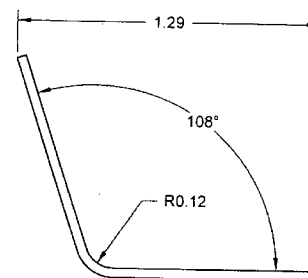
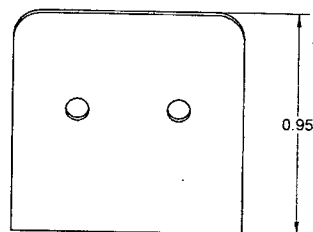
W/O 55848

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

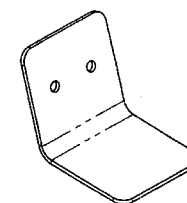
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09.10.19

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-9	JCA-M47-2-08



D4005-9 ANGLE



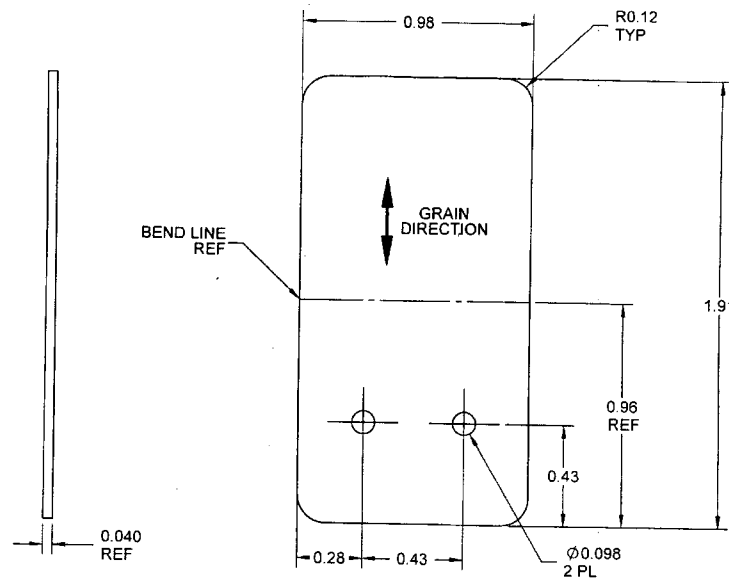
RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4005-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-9" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

W/O 558-18

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D4005-9F FLAT PATTERN

RELEASED
2010-05-05
WJD

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PER QQ-A-250/4 OR AMS-QQ-A-250/4
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REF DART SPEC M2024T3S.040
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W1055048

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